

Work Order ID 131712

Tuesday, April 21, 2015 1:47:28 PM

131712

Page 1

Item ID: D3407-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tow Ring
 Start Date: 4/20/15 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 15-04-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3407	Rev E

100 Large Fab 0.00
100
 Large Fab Memo 0.02
 Large Fab Weld D3407-1/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004
 A/R TIG174 ROD Batch: 102576 12 15-09-08 JA

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
 QC Memo 0.00 (12) 15-09-09 DAS
 Quality Control 9-89

120 QC5- Inspect part completeness to step on W/O 0.00
120
 QC Memo 0.00 (12) 15-09-09 DAS
 Quality Control 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130	<i>m 131545</i>					<i>12.</i>	<i>φ.15-9-10.</i>		<i>888</i>
Powdercoat	Memo	0.01							
Powder Coating	**Mask Threaded Section** START TIME: <i>10:55</i> OVEN TEMPERATURE: <i>1400°</i> FINISH TIME: <i>11:25</i>								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <i>SK530</i>	0.00							
150									
Packaging	Memo	0.01							
Packaging									

(12) *DAS 38*
SEP 10 2015
12 *DAS 6*
9-89 *SEP 10 2015*

DQA: _____ Date: _____



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160

QC21 - Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

ML5 SEP 10 2015

SH 01609102
20150910

DQA: _____ Date: _____



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Picklist Print

Tuesday, April 21, 2015 1:47:28 PM

Page 1

Work Order ID: 131712

131712

Parent Item: D3407-041

D3407-041

Parent Item Name: Tow Ring

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A05.10.14New issueKJ/EC

IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3407-1

Manufactured No

100

Each

33.0000

1

8

D3407-1

Stem

15-08-08
JBC

Location

Loc Qty

Loc Code

WA001

33

129410

33

D3407-5

Manufactured No

100

Each

25.0000

1

8

D3407-5

Ring

15-09-08
JX

Location

Loc Qty

Loc Code

WA001

25

124368

2

126294

10

129160

13

134460

8

14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

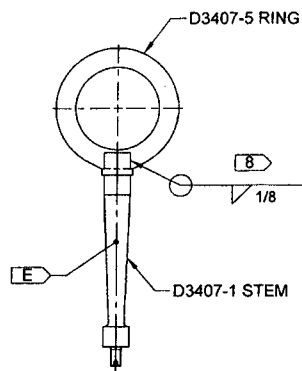
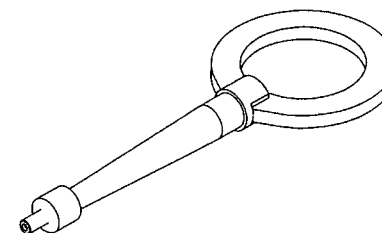
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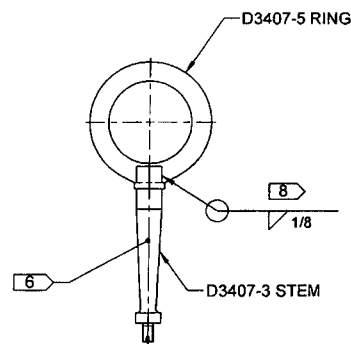
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

SHOW COPY
REF ID: A5-1
UNCLASSIFIED
DATE 10/10/2001
BY: [illegible]

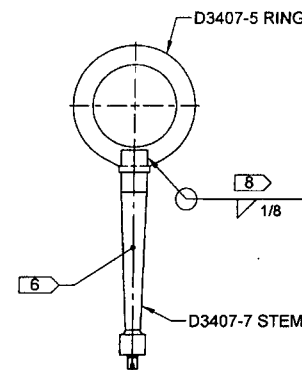
NO. 131712 MJS
150423



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

RELEASED
07-08-01/10

NOTES:

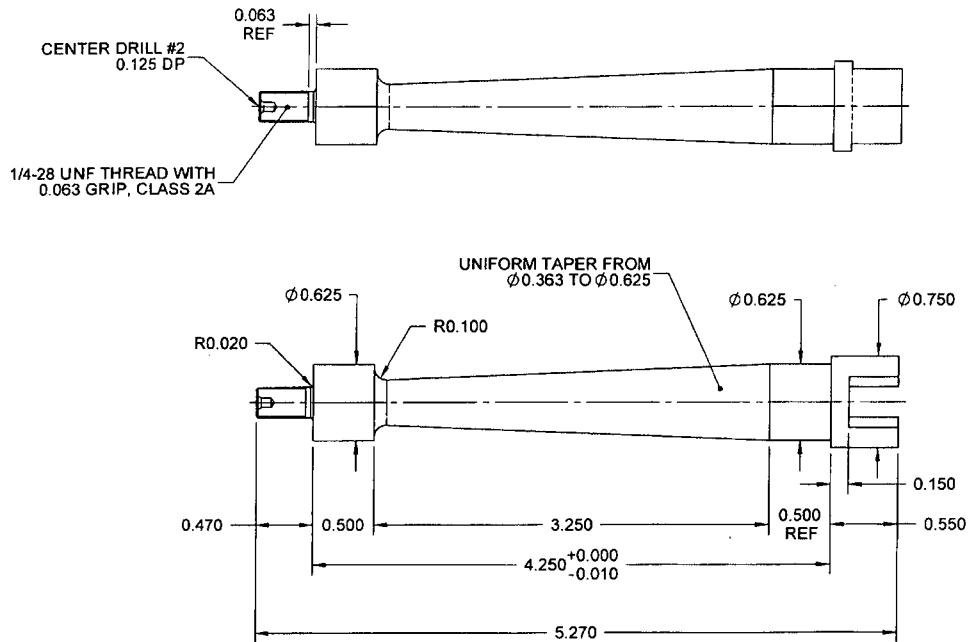
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.23		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3407** REV. E
SHEET 1 OF 5
TITLE **TOW RING** SCALE NTS

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



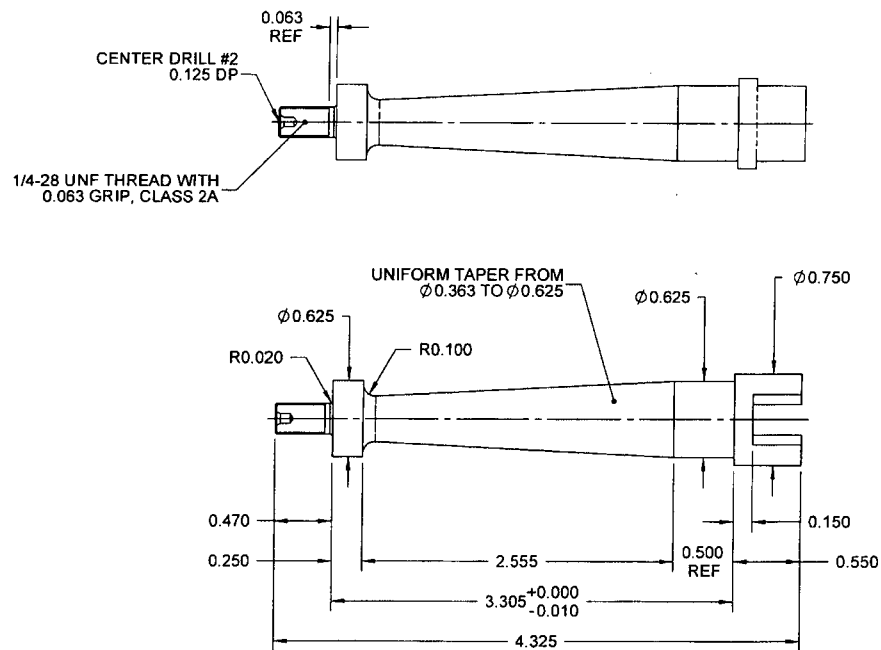
D3407-1 STEM

NOTES:

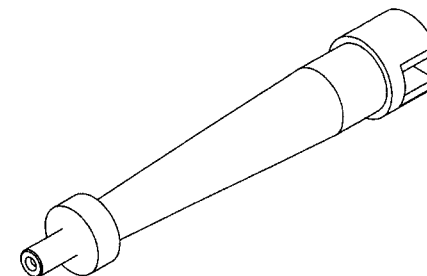
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
08-07-23



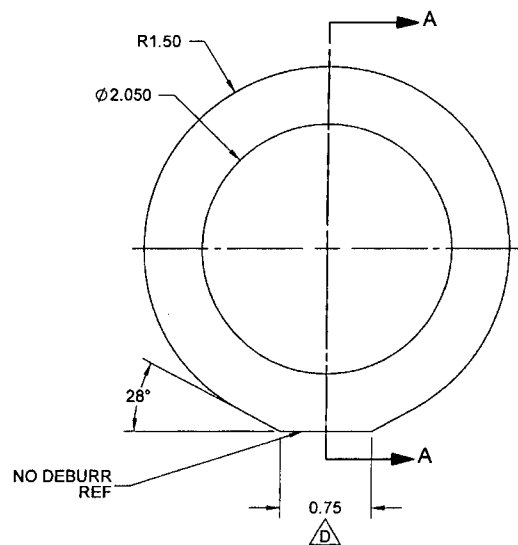
D3407-3 STEM



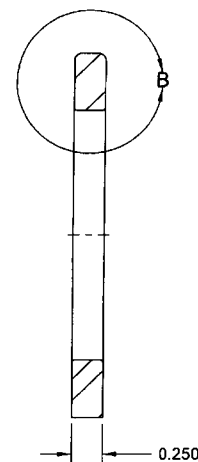
RELEASED
08-07-23

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

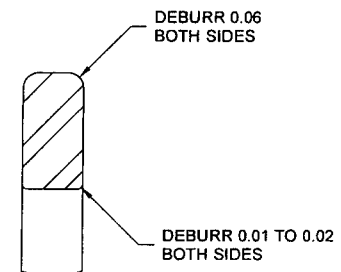
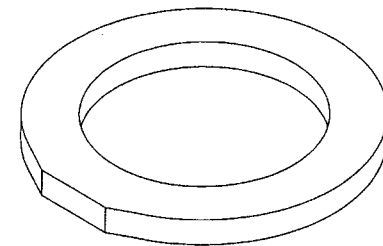
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

RELEASED
08.08.01/11/11

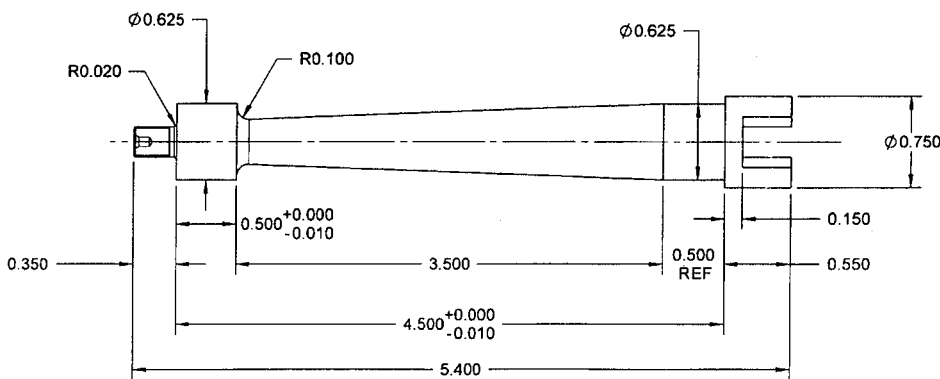
- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN	92	DART AEROSPACE USA, INC.	
DRAWN	1/11	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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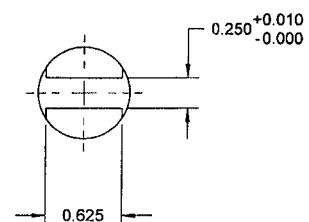
8 7 6 5 4 3 2 1

0.063
REF
CENTER DRILL #2
0.125 DP

1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



E D3407-7 STEM



RELEASED
08-07-23

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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8 7 6 5 4 3 2 1